



Guidelines for Spraying of Conductive Products

PREPERATION:

- If the product is stored frozen allow container to acclimate to room temperature and dry any condensation before opening container.
- Use a spatula to mix and be sure to scrape any material off the bottom of the container if settling has occurred.
- Close the container tightly and vigorously shake the container or place container on a roller overnight. Check to make sure the ink is homogenous.
- If material is “ready to spray” you may load the material for spraying. To spray higher viscosity materials consult the data sheet or contact technical services for recommended dilutions.

EQUIPMENT:

- A wide range of spray equipment can be used including air brush (siphon fed) and automotive (gravity fed) spray guns. Pressure pots can be used for high volume spraying with low pressure.
- Agitation in the reservoir is important with conductive products, if there is no mechanical mixing on your spray gun, be sure to manually agitate by moving the gun in a circular motion before each pass.
- Nozzle diameters vary with filler sizes and geometries to apply the highest quality coating without clogging. Most applications require an orifice of 20-40 mils (0.5 – 1.0 mm).

APPLICATION RECOMMENDATIONS:

- Rather than filling the reservoir, always start by loading small amounts of product until an optimum process is determined.
- If the spray mist does not look uniform try adjusting the nozzle to be tighter, if this does not work add recommended solvent for dilution in 5-10% by weight additions.
- If the mist looks uniform but the sprayed coating has poor uniformity, try moving your spray gun closer to the part, if this does not work add recommended solvent for dilution in 5-10% by weight additions.
- Each spray pass should overlap 30-50% with the previous pass and overlap should be maintained evenly for each pass.
- Many thin coatings will produce the best coating and should be applied across different axes, horizontal, vertical, and diagonals.
- To avoid acceleration and deceleration effects on coating thickness, begin spraying off the part and move at a consistent rate across the part finishing the spray off the part as well.